Qtv:

User:

Wednesday, 11/06/2008 11:02:59 AM

Julie Lecocq

Process Sheet

Customer Job Number

: CU-DAR001 Dart Helicopters Services

: 39818

Estimate Number : 11172

P.O. Number

This Issue

: 11/06/2008

: NC

: 11 : 37850

S.O. No. :

Type : MACHINED PARTS

08.6.1

Part Number

Drawing Name

Drawing Number

: D22827 - D2282 REV E

: TUBE

: N/A **Project Number**

Drawing Revision : E

Material

Due Date

: 27/06/2008

50 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By Comment

: Est Rev:A

Removed from 9 Digit

05-12-02 JLM

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

M304TR0675W091

304 RD Tube .675 x .091W



Comment: Qty.:

0.0699 f(s)/Unit Total: 3.4965 f(s)

Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness

(M304TR0.675W.091)

Batch (1)

2.0

HARDINGE

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2282 and Folio FA190

2-Deburr QC2

THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

3.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No:	PAR #:	Fault Category:	NCR: Yes N	o DQA:	Date:
			QA: N/C	Closed:	Date:

NCR:			WC	RK ORD	DER NON-CONFORMANO	CE (NCR)								
		Description of NC		Corrective Action Section B			Verification	Approval	Ammerical					
DATE	STEP	Section A	-	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector					
								:						

Date:

Wednesday, 11/06/2008 11:02:59 AM

User: ' Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 39818

Part Number: D22827

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





08/06/23 of MF 08-06-20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		·								

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	Closed:	Date:

NCR:			NORK ORDI	ER NON-CONFORMANO	CE (NCR)	(NCR)						
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C						
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DART AEROSPACE LTD	Work Order:	39818
Description: Handle Tube	Part Number:	D2282-7
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	-41	X First A	Article	Prot	otype
Drawing	T-1	Actual	A 4	Daire	Meth

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.795	+/-0.010	,795	0,			
0.493	+/-0.010	:483	V	,		
0.675	+/-0.010	.648	1			
	111					
	20			1.9	10	
		•				

Measured by: MW	Audited by:	m	Prototype Approval:	N/A
Date: 08/06/18	Date:	08/06/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
В	05.04.19	0.795 was 0.750	KJ/JLM	
С	06.03.15	Dwg Rev update	KJ/JLM	
D	07.07.17	Dimensions added per Dwg Rev. E	KJ/JLM J	B

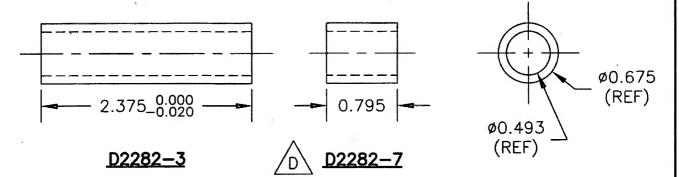
W/O:		WORK ORDER CH	ANGES									
DATE	STEP	PROCEDURE CHANGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
	,											

Part No:	PAR #:	Fault Category:	NCR: Yes	No D	DQA:	Date:	
			QA: N/	C Clos	sed:	Date:	

NCR:		V	WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC		Corrective Action Section B		Verification	Approval	Approval			
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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		9									

DESIGN BW	DRAWN BY	DART AERO HAWKESBURY, G			
CHECKED	APPROVED	DRAWING NO.		REV.	Έ
W	1000	D2282	SHEET	1 OF	2
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05.06.07		HANDLE TUBES			1:1
	94 10 14	NEW ISSUE			

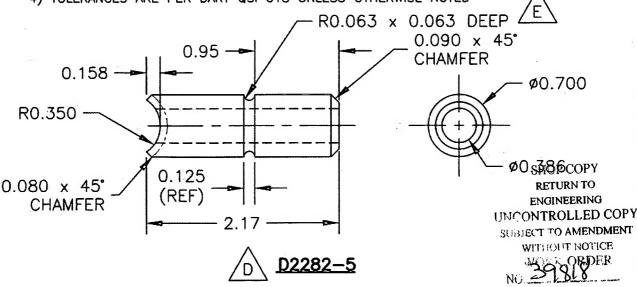
i .		1
05.0	6.07	HANDLE TUBES 1:1
Α	94.10.14	NEW ISSUE
В	95.03.23	RE-DESIGN
С	97.10.20	CORRECTED NUMBERING SCHEME
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
Е	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)



- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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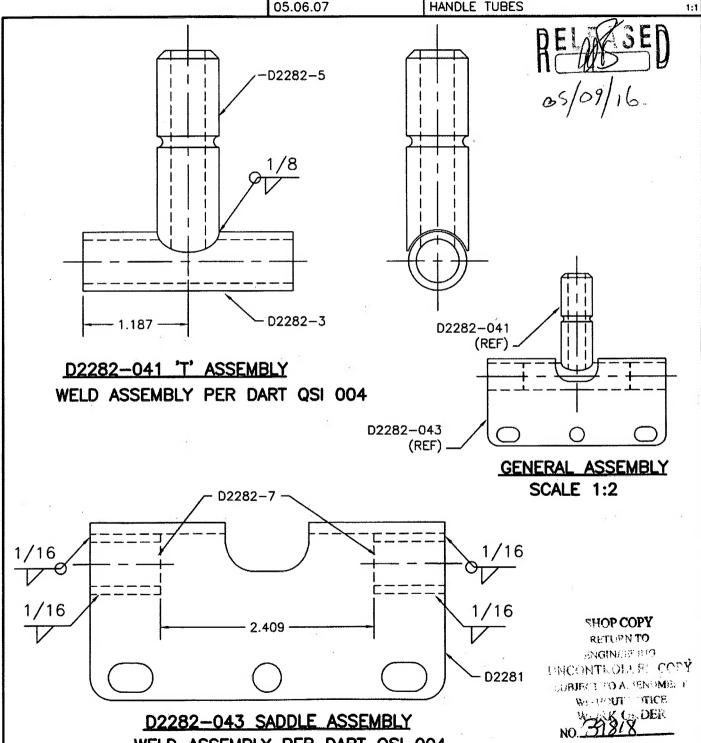
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Dart Ae	rospace	Ltd					•	
W/O:			W	ORK ORDER CHANGES	3			
DATE	STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·	ī				
Part No	:	PAR #:	Fault Cate	gory: N		No DQA:		
NCR:		\	WORK ORD	ER NON-CONFORMAN				
		Description of NC		Corrective Action Section B			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng			Verification Section C	Chief Eng	QC Inspector
	1							

DATE	STEP	Section A	Initial Action Description Sign Chief Eng Chief Eng Da			Section C	Chief Eng	QC Inspector
							`	
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DESIGN BW	ORAWN BY		EROSPACE LTD URY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. E
u'	IND	D2282	SHEET	2 OF 2
DATE	- 100) -	TITLE		SCALE
05.06.07		HANDLE TUBES		1:1



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D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004

W/O:	•			WORK ORE	ER CHANG	SES				of V	
DATE STEP			PROCEDURE C	HANGE			Ву	Approval QC Inspector			
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Part No: PAR #:			: Fault C	ategory:		_ NC	R: Yes	No DQ	\:	Date:	
							QA: N	/C Closed	d:	Date:	
NCR:			WORK O	RDER NON-	CONFORM	ANCE	E (NCF	R)			
		Description of N	ıc	Corrective Action Section B				Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Actio	n Description Chief Eng		Sign 8 Date	Section C		Chief Eng	QC Inspector
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